

Work Order ID 165219

Wednesday, August 16, 2017 3:04:17 PM

165219

Page 1

Item ID: D2608 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket, 407 Console
 Start Date: 8/18/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/23/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: AUG 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2608	Rev A1								
100		0.00							DAS 40 9-89
100	FLOW WATER JET								
Waterjet	Memo	0.58							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A2</u> Prog Rev: <u>A2</u> 2-Deburr if necessary								
110		0.00							DAS 40 9-89
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.02							
Quality Control									
120		0.00							DAS 38 9-89
120	QC8- Inspect parts - second check								
QC	Memo	0.04							
Quality Control									

AUG 21 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Bend as per dwg NC BRAKE Memo	0.17 0.29			DAS 30 9-89	(2)			SEP 13 2017
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				2	Ø		SEP 13 2017 DAS 19 9-89 DAS 9 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.62				(2)	Ø		2017-09-13 JSC

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.02							
Quality Control									
170	Identify as per dwg & Stock Location 51008A	0.00							
170									
Packaging	Memo	0.02							
Packaging									
180	QC21 - Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.20							
Quality Control									

SEP 14 2017

DAS
21
9-89

DQA: _____ Date: _____



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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 165219

165219

Parent Item: D2608

D2608

Parent Item Name: Bracket, 407 Console

Start Date: 8/18/2017

Required Date: 8/23/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP E 02.06.05 Added alodine finish TSR 1290NG
IPP Rev F Added Rev.A 1 07-11-01 DD
IPP Rev:G now water jet 07-11-12 DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	36.5000	0.9	1.8			DAS 40 9-89
M2024T3S 040									**			17/08/17	
2024-T3 .040 sheet													

Location

Loc Qty

Loc Code

MAT022

36.5

m137884

36.5

2

DQA: _____ Date: _____



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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART

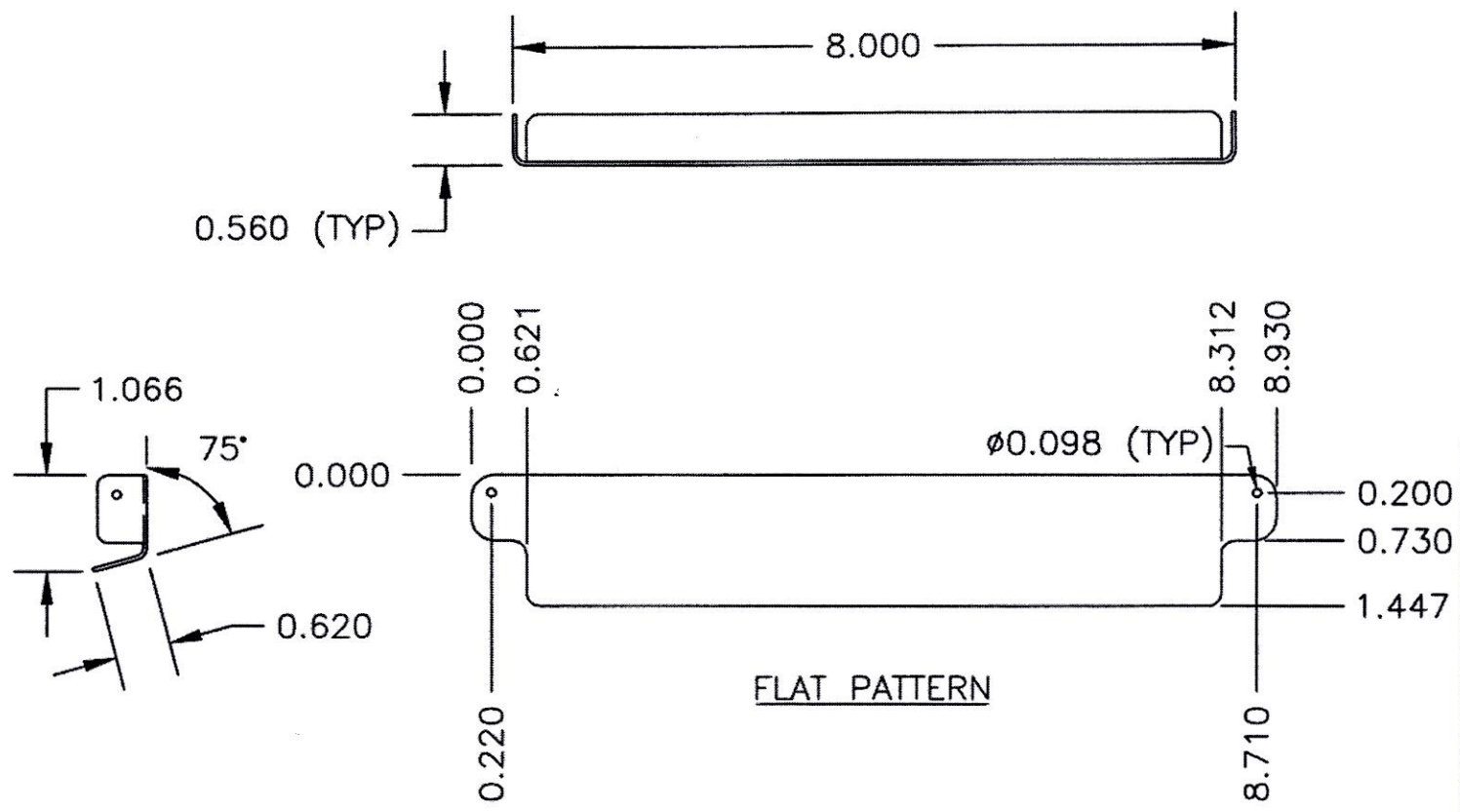


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. A
BW	BW		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	KE	D2608	
DATE	TITLE	SCALE	
97.10.23	CONSOLE BRACKET	1:2	
A	97.10.23	D2608 WAS D206-547-25	
AI	02.06.04	ADD FINISH	

RELEASED
97.11.04 KE
TSR 4421

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165219 MCS
1708-17

FLAT PATTERN



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2608
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1



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